

5/37

DART AEROSPACE LTD	Work Order:	24251
Description: Nut Plate	Part Number:	D3415-041
Dwg: D3415 Rev. B	Qty:	12
		Page 1 of 1

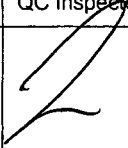
Step	Location	Procedure	By	Date	Qty												
1	DC	Issue Traveler	JA	05.10.04	12												
2	PG	Issue P/O: <u>2008758</u> Email or Ship DXF file to vendor Laser Cut D3415-1 flat pattern as per Dwg D3415 Possible Supplier: Industrial Laser Material release note is required	JA	05/10/04	12												
3	RG	Receive and Inspect for transit damage Enure material release note is attached	CL	05/10/13	12												
4	QC6	Inspect dimensions as per Dwg D3415	CL	05.10.17	12												
5	GA	Deburr	SB	05/10/18	12												
6A	GA	C'sink as per Dwg D3415	SB	05/10/18	12												
7	FP	Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3	MM	05.10.25	12												
8	QC3	Inspect Powder Coat	SB	05/10/26	12												
9	GA	Install Nut plate as per Dwg D3415 Pick: MS20477F3-3 per Chris L <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>2</td><td>MS20613-3C3</td><td>Rivet</td><td>M17654</td></tr><tr><td>1</td><td>MS21070L4</td><td>Nut Plate</td><td>M18762</td></tr></table> Identify as D3415-041	Qty	Part Number	Description	Batch	2	MS20613-3C3	Rivet	M17654	1	MS21070L4	Nut Plate	M18762	SB	05/10/26	12
Qty	Part Number	Description	Batch														
2	MS20613-3C3	Rivet	M17654														
1	MS21070L4	Nut Plate	M18762														
10	QC5	Inspect work to Step 9	CL	05.10.26	12												
11	ST	Identify and Stock	PU	05-10-26	12												
12	AC	Cost / part: <u>7.77</u>	545	05.10.27	12												
13	DC	Close W/O <u>7.77</u> Inspect Level 21	CL	05/10/26													

Rev	Date	Change	Revised By	Approved
A	05.10.03	New issue	KJ/JLM	


RELEASED

12/05.10.18 121

Dbb/als | Inspect c'sink

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	
05-10-18	6	Add an inspection for C'sink permanent change					 05-10-18	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

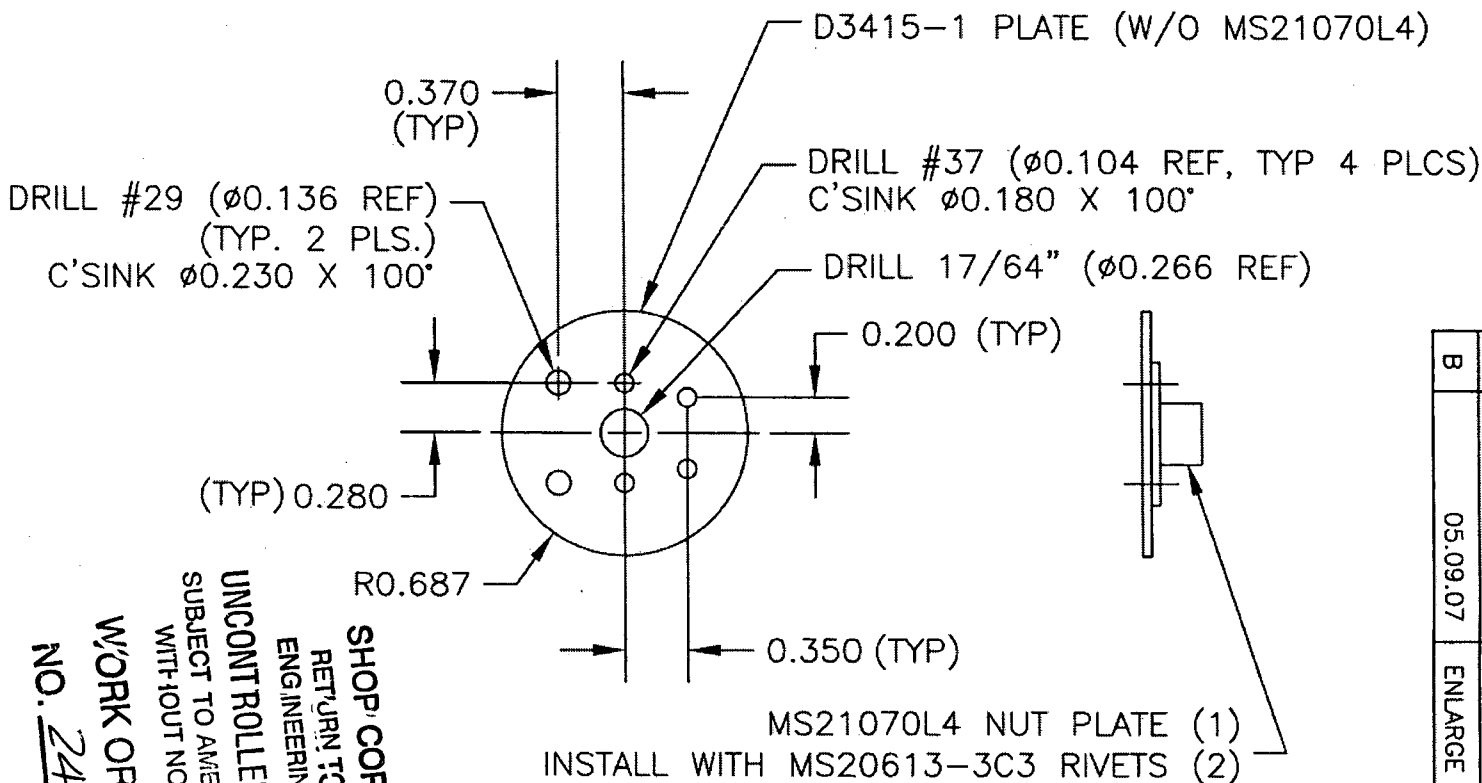
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA:  Date: 05/10/07.

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE USA, INC.
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	PORT HADLOCK, WA
DATE	05.09.07	DRAWING NO.	D3415	REV. B
		TITLE	NUT PLATE	SHEET 1 OF 1
		SCALE	1:1	
A	05.03.16	NEW ISSUE		
B	05.09.07	ENLARGE ALL HOLES FOR POWDER COAT		



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 24251

D3415-041 NUT PLATE

- 1) MATERIAL: AISI 304 SS SHEET, 0.063 THICK
(16 GAUGE, REF DART SPEC. M304S16GA)
- 2) FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

RELEASED
05.09.07-11

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Oct 04, 2005
10:06 am

Work Order No : 0024251
Project Name : D3415-041
Project For : WK537
Work Order Type : Sub
Main WO Number :
House Part Number : D3415-041
Description : Nut Plate
Manufactured : Yes
Amount Req'd : 12
Amount Done : 0
Start Date : 09-13-05
Est Finish Date :
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00



New Zealand Steel Limited
Glenbrook, South Auckland
Postal: Private Bag 92121, Auckland, New Zealand
Telephones: (09) 375 8999 / 375 8111 Auckland
(09) 235 8069 / 235 3535 Waiuku
Fax: (09) 375 8959

TEST CERTIFICATE

Ref: 5078/21768

CUSTOMER		Wilkinson		SPECIFICATION														ASTMA1008 CS Type A		CERTIFICATE No		TC109561					
CUSTOMER O/N		90-21N-540		PRODUCT														CRA WIDE COIL		PAGE		1 of 1					
MILL O/N		471159		DIMENSIONS														0.055" x 48" x Coil		DATE		23 April 2005					
PACK NUMBER	HEAT No	CHEMICAL COMPOSITION PERCENT														MECHANICAL TESTS (TEST SPECIFICATION - ASTMA370)											
		C	Si	Mn	P	S	Cu	Ni	Cr	Mo	V	Nb	Ti	Al	B	N2	CE ()	BEND	YIELD	T.S.	%ELONG	HARDNESS	r	LENGTH			
		x100			x1000											x10000		x100		180°				G.L.=	HRB	()	(feet)
R9-457097-00	640590	4	TR	20	13	17	12	17	20	1	8	1	1					Good				46		1562			
R9-457098-00	640590	4	TR	20	13	17	12	17	20	1	8	1	1					Good				46		1483			
R9-457099-00	640590	4	TR	20	13	17	12	17	20	1	8	1	1					Good				46		1562			
R9-457100-00	640590	4	TR	20	13	17	12	17	20	1	8	1	1					Good				46		1496			
R9-457101-00	640590	4	TR	20	13	17	12	17	20	1	8	1	1					Good				47		1562			
R9-457102-00	640590	4	TR	20	13	17	12	17	20	1	8	1	1					Good				47		1555			

YIELD		GAUGE LENGTH (G.L.)		PLASTIC STRAIN RATIO (r)		IMPACT TEST		CARBON EQUIVALENT VALUE (CE)	
(A)=0.2% PROOF STRESS	(B)=LOWER YIELD STRESS	(A)=200mm	(C)=80mm	(E)=2"	(F)=8"	(A)=10mm x 10mm	(B)=7.5mm x 10mm	(A)=C+Mn/6	(B)=C+Mn/6+(Cr+V+Mo)/5+(Cu+Ni)/15

WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS BEEN TESTED AND INSPECTED WITH SATISFACTORY RESULTS IN ACCORDANCE WITH THE REQUIREMENTS OF THE ABOVE SPECIFICATION

APPROVED *Satish Misra*
QC METALLURGIST

16 ga crms

S50627MD015-1 T M INDUSTRIAL (P50128DI003 .640590)